Dart Aerospace Ltd.

Date: Monday, 10/12/2007 7:53:17 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D2003-037
Job Number	: 36204		
Estimate Number	: 10804		
P.O. Number	: N/A	**Part Number**	: D2003037A
This Issue	: 10/12/2007 **S.O. No.** : N/A	**Drawing Number**	: ~~PROTO~~ U/R Rev B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : SMALL /MED FAB	**Drawing Revision**	: N/A
Previous Run	: 00015	**Material**	: N/A
Written By	:	**Due Date**	: 14/12/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	:		

LE 07.12.19

LE 07.12.11

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W

Comment: Qty.: 2.0457 f(s)/Unit Total : 2.0457 f(s)
304 RD Tube .500 x .035W
Cut as per template D2003-037 (23.38" long)
Material:1/2"Æ x 0.035" wall AISI 304 SS tubing
Cut: 23.38" long as per Dwg D2003
Material: M2650-6 Heat sleeve
Batch: ~~M106075~~ M 103097 Batch: M106015

FF 07-12-10 1

2.0	M26506	Firesleeve-crkl .375IDia

Comment: Qty.: 2.0700 f(s)/Unit Total : 2.0700 f(s)
Firesleeve-crkl .375IDia ~~M103097~~

FF 07-12-10 1

3.0	MS208198J	Sleeve

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick
Qty Part Number Desc Batch:
2 MS20819-8J Sleeve M103344

FF 07-12-10 1

4.0	AN8188J	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick
Qty Part Number Desc Batch:
2 AN818-8J Nut M106074

FF 07-12-10

Form: rprocess

Date: Monday, 10/12/2007 7:53:17 AM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd. **Drawing Name:** D2003-037

Job Number: 36204 **Part Number:** D2003037

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D3158045	Heat Shrink 1" x 4.5"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Heat Shrink 1" x 4.5"
Pick:

Qty	Part Number	Description	Batch
1	D3158-045	Heat shrink	B24615

FF 07-12-10 1

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Form tube as per template D2003-037 -
*** 1" longer per David S. visit to Highland ****
Assemble as per Dwg D2003

FF 07-12-11 (1)

7.0	QC5	INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL LE 07.12.12

Comment: INSPECT WORK TO CURRENT STEP

8.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST192

07.12.19

9.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

(1) FD 07/12/20

Job Completion

POSITIVE RECALL
EFFECTIVE 07-12-10 AUTH
PO ____ DATE ____
N/A
LE 07.12.11

07.12.19

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** DD **Date:** 07/12/20

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
07.12.11	6.0	PART TO BE 1" LONGER THAN TEMPLATE. (LONGER ON END AFTER SHARPER BEND)	LE 07.12.11	ACCEPTABLE	LE 07.12.11	↓ AH/14	LE 07.12.11	↓ AH/14

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2003	REV. B SHEET 1 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES	SCALE NTS

A	90.04.09	NEW ISSUE
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)

RELEASED
99.06.08 KE

UNDER REVIEW
00.08.21 CB
some flat lengths wrong

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WORK ORDER No. 36204

P/N	TEMPLATE	HEATSLEEVE LENGTH[1]	CUT LENGTH OF TUBE[2]	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2003	REV. B SHEET 2 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES	SCALE NTS

DART

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RELEASED
99.06.09 KE

UNDER REVIEW
06.08.21 CB
Some Flat lengths ~~not~~ wrong

Notes:

(1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.

(2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.

(3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.

(4) ENSURE SEAMLESS TUBING IS USED.

(5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.

(6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.

(7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.

(8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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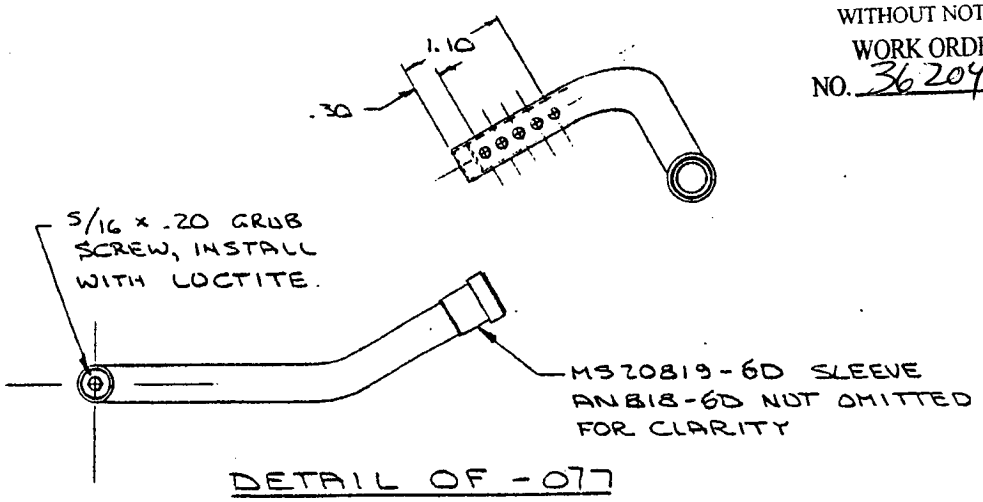
NO. 36204



DETAIL OF -077